

Nov 23

Work Order ID 76328

76328

Page 1

November-09-11 8:34:25 AM

Item ID: D4032-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 23/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.5

Date: 11/11/09

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4032

D

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00

110

HandFinish

Memo

0.00

Hand Finishing

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

Signature

1 BR11-11-22

Signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 8:34:29 AM

Page 1

Work Order ID: 76328

76328

Parent Item: D4032-041

D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-232 *D4086-232* Placard, Max Load		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST122				4					
				72052				4		72052			
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	10.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				9					
				74600				9		74600			
				ST508				1					
				69318				1					
D2535 *D2535* Spring		Manufactured	No			100	Each	50.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				50					
				71117				50		71117			

W/O:		WORK ORDER CHANGES					
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D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No

100 Each

27.0000

2 2

D2537

**

Bushing

Location

Loc Qty

Loc Code

ST504

27

73344

27

D3917-3 Manufactured No

100 Each

29.0000

6

D3917-3

**

Washer

Location

Loc Qty

Loc Code

ST092

29

75036

29

D3953-3 Manufactured No

100 Each

15.0000

2

D3953-3

**

Gas Spring Stud, Lid

Location

Loc Qty

Loc Code

ST096

15

74703

15

D3953-7 Manufactured No

100 Each

5.0000

2

D3953-7

**

Spring Spacer

Location

Loc Qty

Loc Code

ST096

5

65053

4

74168

1

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4032-041

D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each 6.0000 2 2

D3953-9

Gas Spring Washer

**

Location

Loc Qty

Loc Code

ST096

6

69025

2

74169

4

74169

D3953-17 Manufactured No

100 Each 10.0000 2

D3953-17

Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST096

10

73474

10

73474

D3953-19 Manufactured No

100 Each 25.0000 1

D3953-19

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST096

25

59213

1

73551

4

75227

20

73551

D3953-21 Manufactured No

100 Each 11.0000 1 1

D3953-21

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST096

11

73557

11

73557

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Work Order ID: 76328

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Parent Item: D4032-041

D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100 Each 25.0000 1 1

D3969-3

Spring (Basket Lid)

**

Location

Loc Qty

Loc Code

ST272

25

64285

1

73515

24

73515

D4017-041 Manufactured No

100 Each 0.0000 1 1

D4017-041

Short Basket Base Assembly (350)

76323

1 BA 11-11-24

**

76323

D4018-041

Manufactured No

100 Each 0.0000 1 1

D4018-041

Short Basket Lid Assembly (350)

76326

1 BA 11-11-24**

AN3-14A

Purchased No

100 Each 140.0000 4 4

AN3-14A

Bolt

**

Location

Loc Qty

Loc Code

ST352

140

117872

40

119328

100

117872

AN3-16A Purchased No

100 Each 141.0000 2 2

AN3-16A

Bolt

**

Location

Loc Qty

Loc Code

ST352

141

117441

53

118628

88

118628

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

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76328

Parent Item: D4032-041

D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

100 Each 46.0000 3 3

AN4-12

Bolt

**

Location

Loc Qty

Loc Code

ST357

46

118626

46

118626

AN5-17A Purchased No

100 Each 144.0000 4 4

AN5-17A

Bolt

**

Location

Loc Qty

Loc Code

FP

50

119438

50

ST338

94

117872

44

119449

50

119449

AN310-4 Purchased No

100 Each 41.0000 3 3

AN310-4

NUT

**

Location

Loc Qty

Loc Code

ST324

19

118983

19

ST344

22

119328

22

118983

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 76328

76328

Parent Item: D4032-041

D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

50.0000

2

2

AN310C4

Nut

**

Location

Loc Qty

Loc Code

ST324

25

118090

5

118626

20

ST344

25

119324

25

118090

MS21042L3

Purchased

No

100

Each

9,347.000

6

6

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

367

117441

16

117885

42

118451

5

118927

304

ST516

6000

119017

6000

ST518

2980

119075

2980

119017

November-09-11 8:34:29 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 76328

76328

Parent Item: D4032-041

D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

2,318.000

4

4

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

ST300

818

116105

5

116548

43

117611

62

118179

496

118910

212

ST518

1500

119109

1500

118910

MS24665-151

Purchased

No

100

Each

374.0000

3

3

MS24665-151

Cotter Pin

**

Location

Loc Qty

Loc Code

ST309

374

17566

374

17566

MS24665-300

Purchased

No

100

Each

230.0000

2

2

MS24665-300

Cotter Pin

**

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

30

116823

30

116823

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 8

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Parent Item: D4032-041

D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

240.0000

6

6

NAS1149F0432P

Washer

**

Location

Loc Qty

Loc Code

ST275

40

119109

40

ST294

200

119307

200

119307

NAS1149C0432R

Purchased

No

100

Each

4,412.0000

2

2

NAS1149C0432R

Washer

**

Location

Loc Qty

Loc Code

ST297

4412

117291

3412

119124

1000

117291

NAS1149F0332P

Purchased

No

100

Each

388.0000

8

8

NAS1149F0332P

WASHER

**

Location

Loc Qty

Loc Code

ST275

388

117735

45

119225

340

17317

3

119225

NAS1149F0563P

Purchased

No

100

Each

139.0000

4

4

NAS1149F0563P

Washer

**

Location

Loc Qty

Loc Code

ST297

139

117735

139

117735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

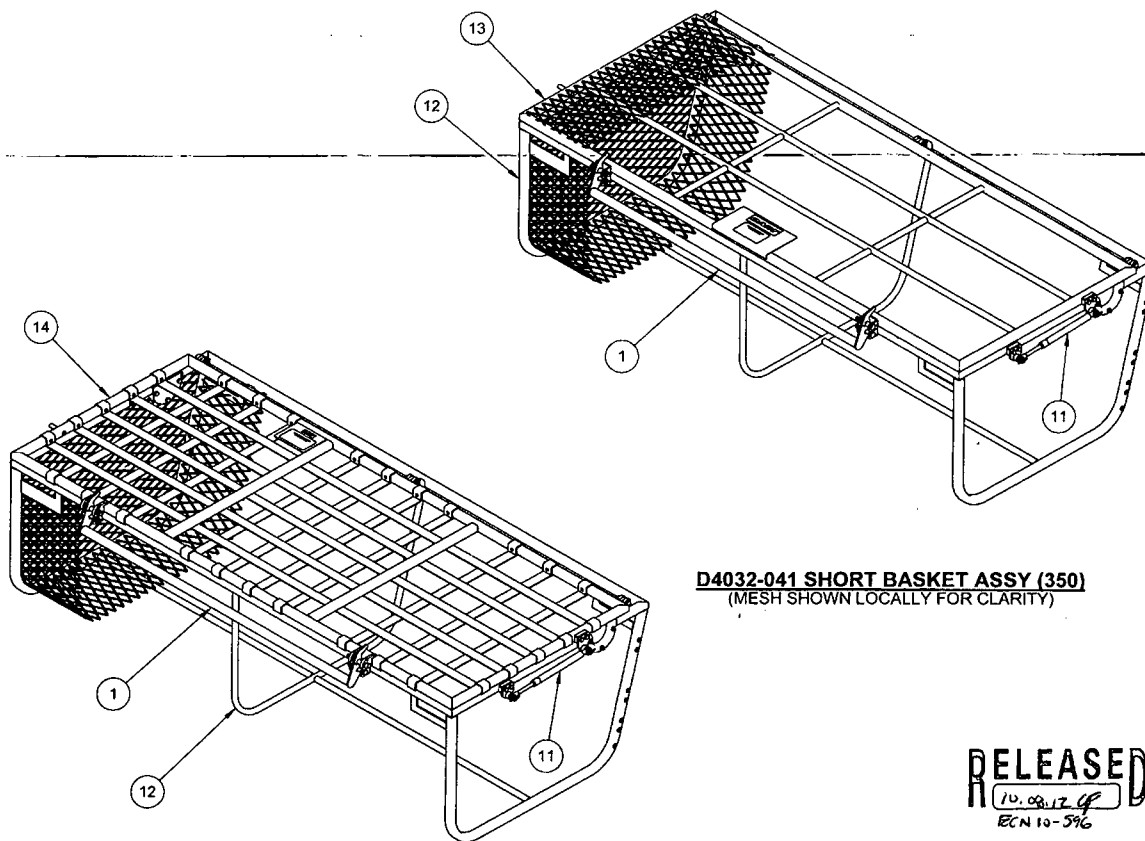
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NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17
ECN 10-596

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76328 M.C.S
11/11/09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED, ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN	AS		
CHECKED	AS		
MFG. APPR.	JES		
APPROVED	WAP		
DE APPR.	CH		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D4032** REV. D
TITLE **SHORT BASKET ASSY (350)** SCALE NTS
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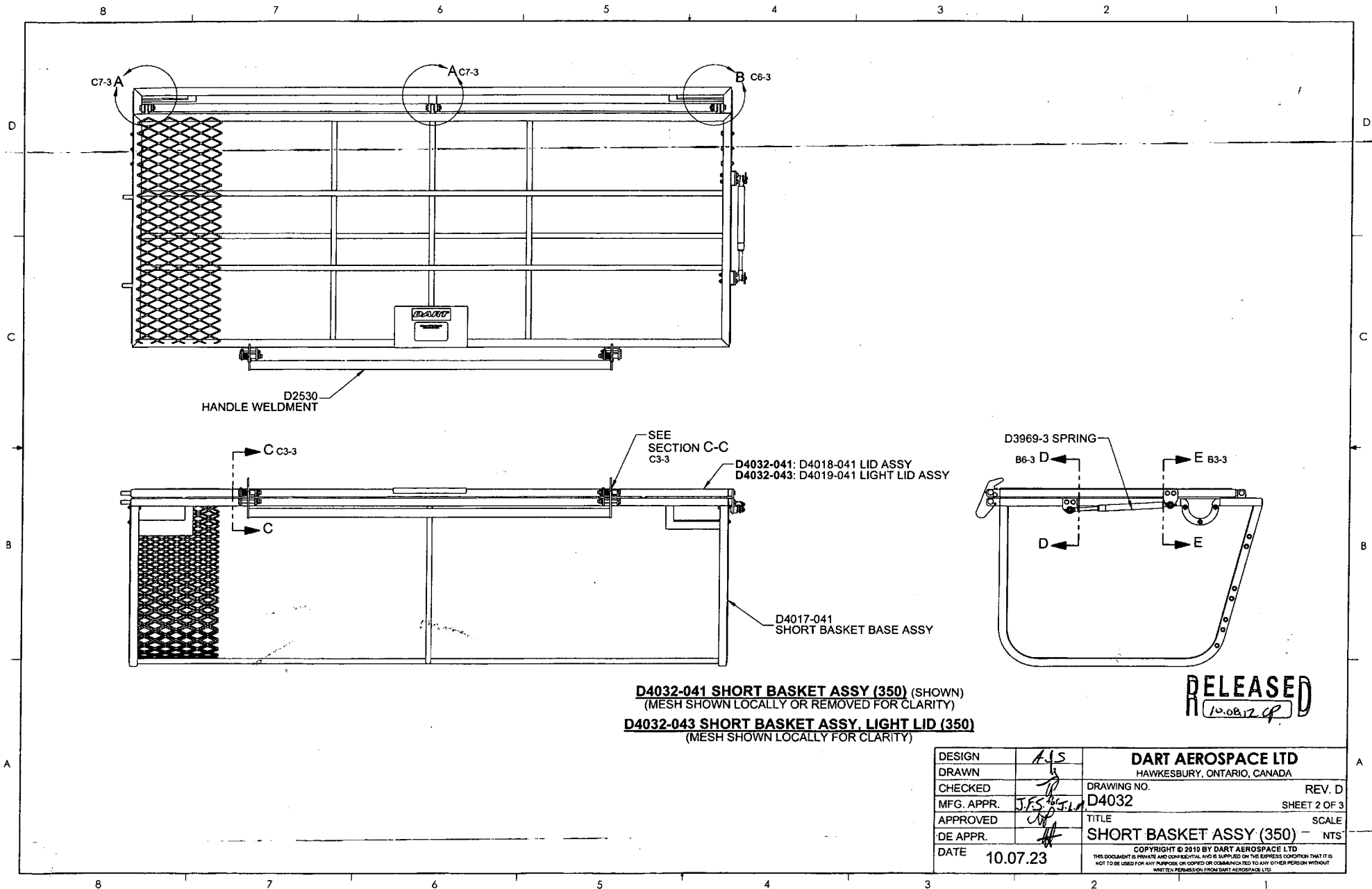
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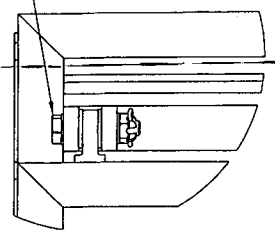
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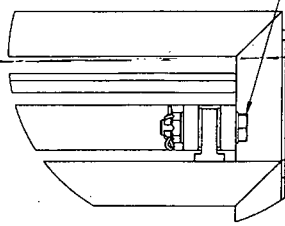
76328

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



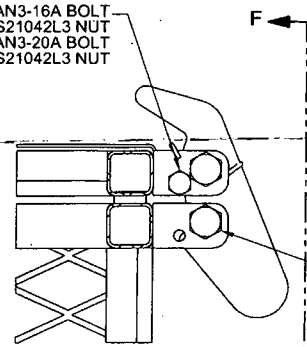
DETAIL A D8-2
D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT

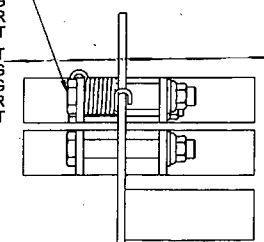


SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

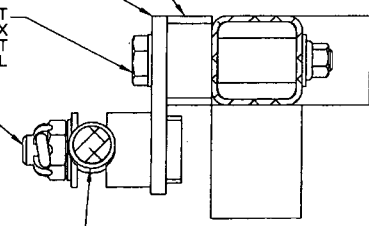
D2530 WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF



SECTION D-D B2-2

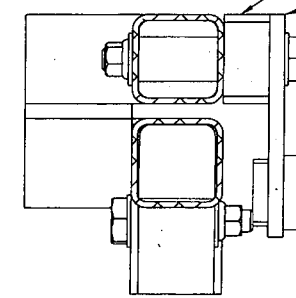
D3953-17 GAS SPRING SPACER

D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF



SECTION E-E B1-2

RELEASED
10.08.17.9

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4032	REV. D
MFG. APPR.	J.F.S. J.M.	SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries